

Work Order ID 92888

Friday, November 09, 2012 2:18:22 PM

92888*Must ship today* Page 1

Item ID: D4012-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Cushion

Stop

NS2

Start Date: 11/9/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/12/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

*MF*Date: *12-11-09*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4012

B

100

0.00

100

Mill Conv

Memo

0.00

*12-11-12**15*

Conventional Milling Machine

110

QC2- Inspect parts off machine FAI/FAIB

0.00

*12-11-12****110***

QC

Memo

0.00

15

Quality Control

120

QC8- Inspect parts - second check

0.00

*12/11/12****120***

QC

Memo

0.00

15

Quality Control

Work Order ID 92888***92888***

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Friday, November 09, 2012 2:18:22 PM

Item ID: D4012-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cushion

Stop ***NS2***Start Date: 11/9/2012 Start Qty: ~~12.00~~ ¹⁵***12***

Cust Item ID:

Required Date: 11/12/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

123

0.00

123

Small Fab

Memo

0.00

Small Fab

CLAMP AND FORM CUSHION AS PER DWG BY SLIGHTLY HEATING IT
WITH HEAT GUN, LET IT COOL DOWN BEFORE REMOVING CLAMP.

1.5

Ø

FF
12-11-12

126

QC5- Inspect part completeness to step on W/O

0.00

126

QC

Memo

0.00

Quality Control

DAS
16
9-83 rzh/kz

①5

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

①5 sel 12/11/12

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92888

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Friday, November 09, 2012 2:18:22 PM

Item ID: D4012-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cushion

Stop *NS2*

Start Date: 11/9/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/12/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 12-11-12

MF
12-11-12

Picklist Print

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Page 1

Work Order ID: 92888

Parent Item: D4012-1

Parent Item Name: Cushion

Start Date: 11/9/2012

Required Date: 11/12/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue 09.10.28 DD verified by:JLM
09.11.18 DD verified by:JLM
by:JLM
IPP RevB: revA as per dwg
IPP Rev:C 11.01.10 as per dwg Rev.B DD verified

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3 UHMW U-Channel		Manufactured	No			100	f	12.0000	0.37	4.6736842			

Location

Loc Qty

Loc Code

ST202

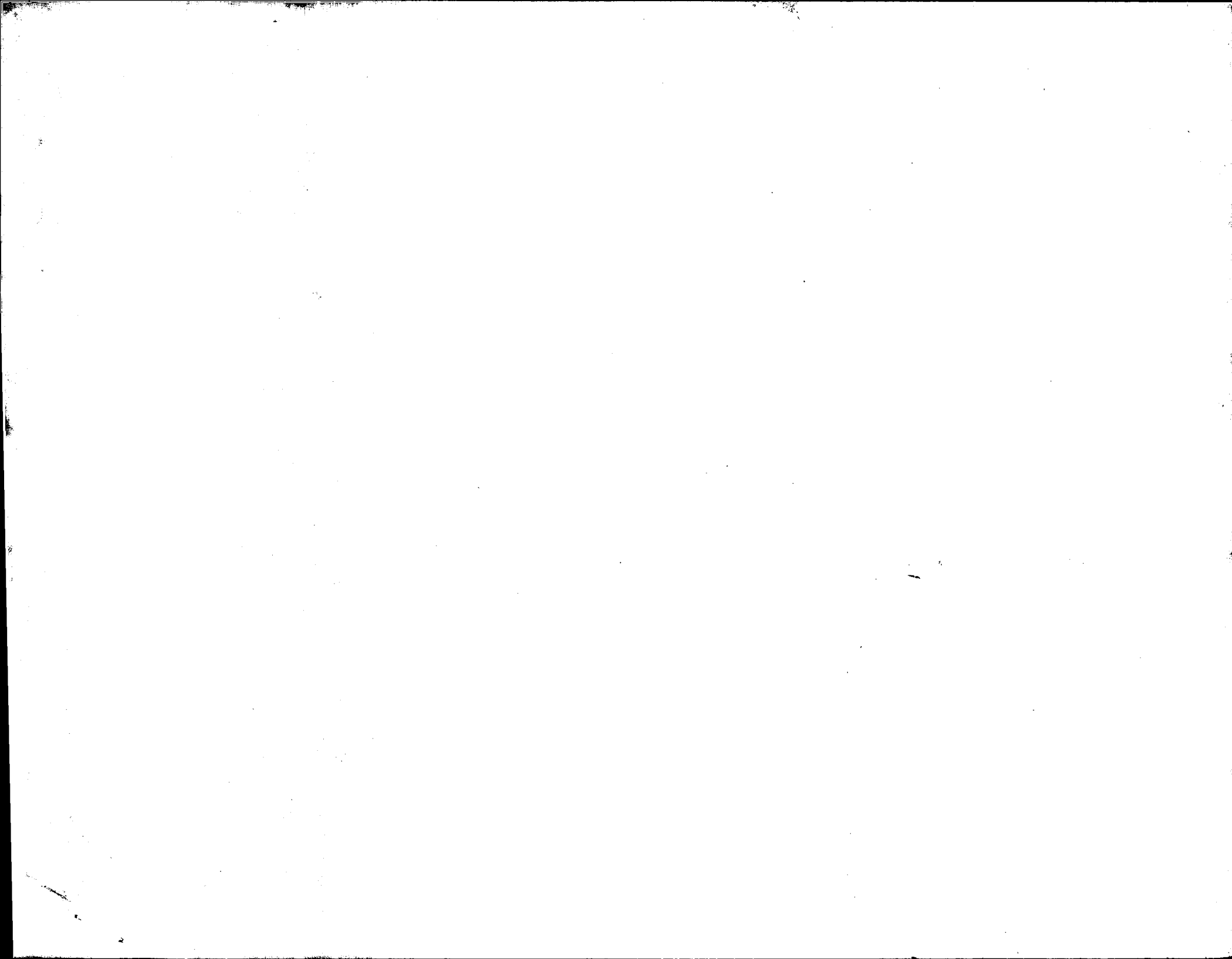
12

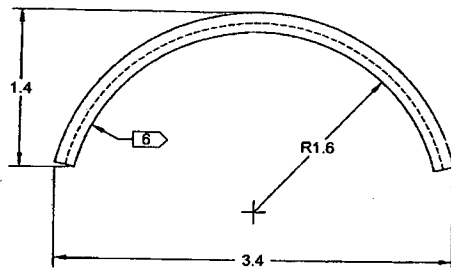
91102

12

5.6

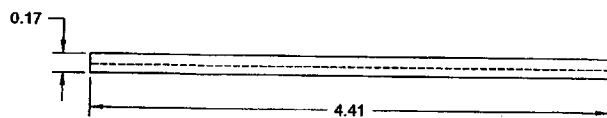
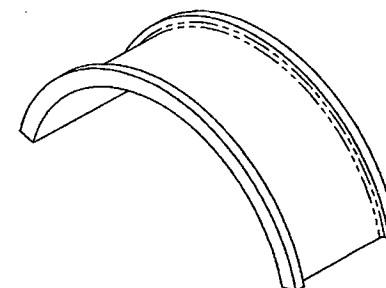
12-11-12



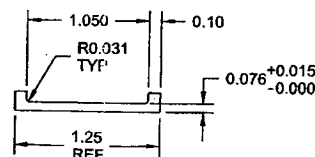


D4012-1 CUSHION
(MAKE FROM D4012-1F)

92888



D4012-1F FLAT MACHINED STATE 1



RELEASED
2010-12-23

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4012** REV. B
SHEET 1 OF 1

TITLE **CUSHION** SCALE NTS

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